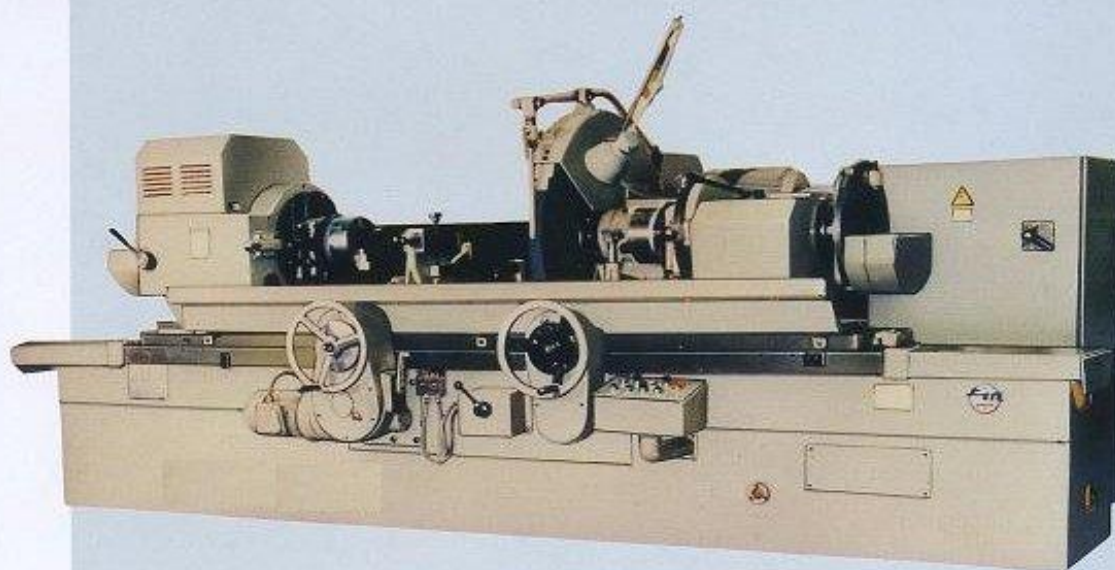


CRANKSHAFT GRINDER

MQ8260B

曲 轴 磨 床



CRANKSHAFT GRINDER

MQ8260B

曲 轴 磨 床

■ 机床性能与用途 Performance and Application

- MQ8260B 型是一种结构简单、操作方便、适用性广的曲轴磨床，适宜磨削曲轴的曲柄颈、主轴颈，也可作外圆磨床使用。
- 机床的左、右卡盘采用可调式十字卡盘。
- 工件用顶尖或卡盘夹持，由头架电机驱动，手动进给磨削。
- 机床由机械、电气、液压控制，以手动操作为主。
- 工作台纵向移动采用手动或机动二种传动方式，机动由电机驱动，用于跳挡或调整。
- 左、右卡盘的最大可调量，垂直方向 110mm。
- 工件、砂轮、工作台、冷却泵、油泵均由单独电机驱动。
- 工作台与砂轮架采用液压、电气联锁机构，无论在调整或磨削误操作也能确保安全。砂轮架装有可靠的防护罩。
- Model MQ8260B crankshaft is simple in construction, easy in operation and wide in application; suitable for grinding the crankshaft pins and journals. It can also be used as cylindrical grinder.
- Left and right chucks are crisscross and adjustable.
- Workpiece is held by centers or by chucks, driven by workhead motor, and fed by hand for grinding.
- The machine is controlled by mechanical, electric and hydraulic means; operated mainly by hand.
- Longitudinal worktable travel is realized by manual-drive or motor-drive, with the motor-drive for jump displacement or adjustment.
- Max. adjustable amount of left and right chucks is 110mm in vertical direction.
- Workpiece, wheel, worktable, coolant pump and oil pump are driven by their individual motors
- Worktable and wheelhead have the hydraulic and electric interlocking mechanism, ensuring the safety even if misoperation whether in adjustment or in the process of grinding.



主轴颈磨削
Journal grinding



连杆颈磨削
Pin grinding



端面外圆磨削
Angular approach cylindrical grinding

■ 机床工作精度 Working Accuracy

圆度 Roundness	5 μ m	表面粗糙度 Surface roughness	Ra0.32 μ m
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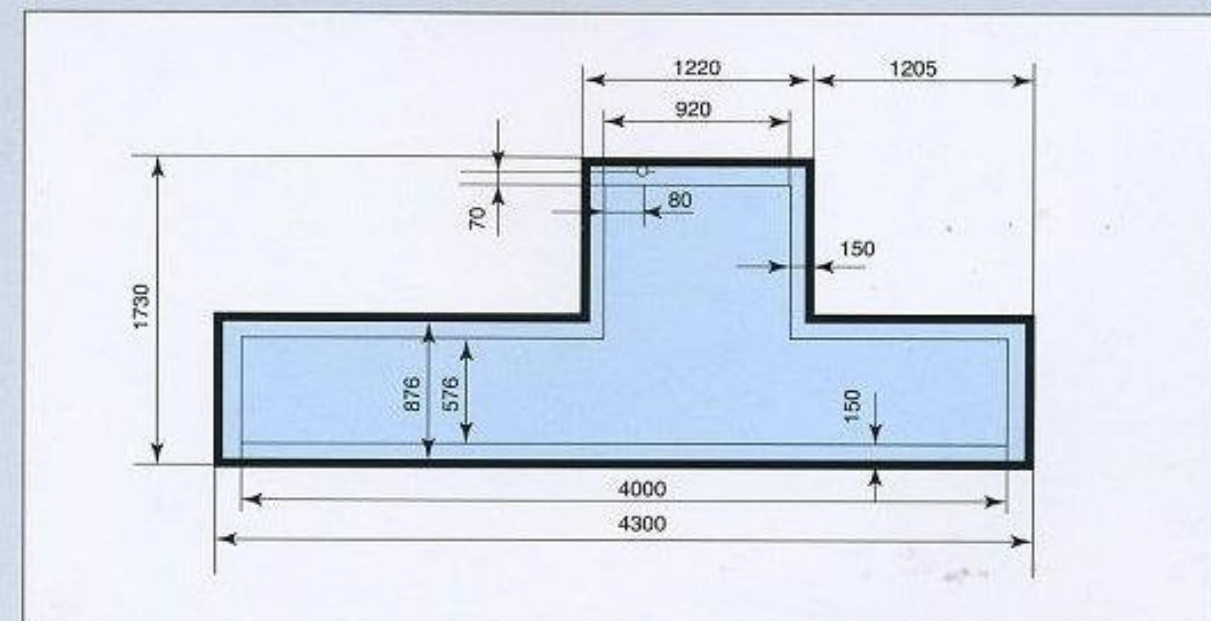
■ 主要附件 Main Accessories

冷却水箱 Coolant tank	1 套 1 set	左、右卡盘 Left & right chuck 各 1 套 1 set each	
砂轮修整器 Wheel dresser	1 套 1 set	端面修整器 End-face dresser	1 套 1 set
垂直样板 Vertical aligning plate	1 套 1 set	水平样板 Horizontal aligning plate	1 套 1 set
机床垫铁 Levelling wedge	11 套 11 sets	中心架 Steady-rest	1 套 1 set

■ 特殊附件 Extra Accessories

悬挂式测量仪 Suspension-type measuring instrument	1 套 1 set	校调装置 Correcting device	1 套 1 set
砂轮平衡架 Wheel balancing stand	1 套 1 set		

■ 安装地基图 Foundation Layout



技术参数表 Table of technical data

名 称 Name	单位	MQ8260B
工作台上最大工件回转直径 Max. swing dia. over table	mm	580
最大曲轴曲柄的半径 Max. crankpin throw	mm	110
在中心架上可磨直径 Grinding diameter supported by steady-rest	mm	30~100
可磨外圆直径 Grinding cylindrical diameter	mm	30~200
最大可磨工件长度(三爪卡盘间) Max. grinding leangth (clamped by 3-jaw chuck)	mm	1300
最大可磨工件长度(顶尖间) Max. grinding length (clamped by centers)	mm	1600
最大工件重量 Max. workpiece weight	Kg	120
中心高 Center height	mm	300
头架主轴转速(三档) Workhead spindle speed (three steps)	r/min	25,50,100
砂轮架主轴转速 Wheelhead spindle speed	r/min	760
砂轮架沿丝杆最大移动量 Max. wheelhead travel along leadscrew	mm	200
进给手轮一转砂轮架移动量 Wheelhead displacement per rev. of feed handwheel	mm	1
进给手轮每格砂轮架移动量 Wheelhead displacement per div. of feed handwheel	mm	0.005
砂轮架快速进退量 Rapid wheelhead advance/withdrawal	mm	100
微进给按钮一次砂轮架移动量 Wheelhead displacement per depressing the micro-feed button once	mm	
工作台最大纵向移动量 Max. longitudinal worktable travel	mm	1600
油泵流量 Oil-pump flow-rate	ml/r	11
油泵压力 Oil-pump pressure	Map	6.3
冷却泵流量 Coolant pump flow-rate	L/min	50
电机总功率 Total motor power	Kw	9.45
机床重量 Machine weight	Kg	6700
机床外形尺寸(长×宽×高) Overall dimensions (L×W×H)	mm	4000x2100x6130

